Work Ord Tuesday, March			<u>.</u>	*980					Page 1				
Revision ID:	D 3 166-1	ð.	4	Accept	*N900	040	100	*	Setup	Start Stop	*N	S1*	
Item Name: Start Date: Required Date:	3/5/2013 • 3/19/2013	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	I D :				P	"N	S7"	
Reference:	. 3/17/2013	Req u Qiy. 12.00	^1 7 ^		Customer.								
Approvals:	Process Plan	n:	Date: 13-03-5	Tooling:	D	ate:		. 1	Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:	· · · · · ·			Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Reje Qty		Reject Number	Insp. Stamp	m +ut
Draw Nbr	Revi	sion Nbr										10. 20 · · · · · · · · · · · · · · · · · ·	
D3166	Rev	A 1											
100 *1 Large Fab		Skidtubes	•	0.00				24		3A)	[c	1-04-2	, ک
Large Fab		Memo Cut 3/4" x 3	/4" square tubing 60.00" to									ين شور شور	
				_								Single State of the State of th	
*110 *110*		BENDING MACHINE -	SKIDTUBES	0.00	`			дч	' (SAI) 1	2 NU	10
CNC Bend 1		Memo		0.00		•	-	-0-1				> 0 1	O o
CNC Delta 100 Ber	nder	Form D3166 BASB, and i	6-1 Basket Hoop as per Dv folio 18.	wg D3166 using Bending	g program 350				<u>.</u>		•	Pto -	- >
120		QC6- Inspect dimensions	s to drawing	0.00									∽ A

Quality Control

Memo

0.00 Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302) $\epsilon^{-\epsilon}$

	\mathcal{A}	
NCR:	(kes)/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DOACTU	_Date: _(3/05/	22	

									QA Closed:	Date:	1715117
Work Orde	er: 9	201	13		DISPOSITION			AGAINST DE	PARTMENT/	PROCESS	
Part N	No. D 3				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube X Small Fab Finishing Composite	Prod	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	(3/04/22	世八八	₽ Zo	tours they be they be templed p.(.	At instati Ofy x20 RiBS Bent encomply not Match the Boss "	952042 Bloglez M	Scrapt Cary +20		SA) 13-05-13	13/15/14	075 16 16 02072 13/4/22
	!	<u> </u>			F.	AULT CATE	GORY	1.12			
Landii	ng Gear				General		L.		_		
	Bending Centre No	ot Concer	ntric to		Bend BOM/Route Broken/Damaged	Grain Hardwa Inspecti	ire ion Incomplete		Ovalized Over/Under Part Incorred	 	Pressure/Forced Temperature/Cure Weld
	Crushed/	Crimped.			Burrs	Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte			Part Moved		
·	Heat Trea			<u> </u>	Countersink	Mislabe	eled	<u> </u>	Positioned V		7
	Inspectio	•	Tube		Cut Too Short	Misread	t		Power Loss/	Surge	Other
ć, .	Ripples ir			ļ	Drill Holes	Offset					
ćά	Torque V			n [Drawing	\vdash	Calibration				
	Turning S	•			Finish	\vdash	Sequence				
•/.	· Wave/Tw	ist in Tut	oe 🕖		Folio	Outside	Dimensions				

Work Ord Tuesday, March				*980	ገ73*					Page
Item ID: Revision ID: Item Name:	D3166-1 Basket Hoop	-		Accept	*N900	<u>040100</u>	* Setup	Start Stop		S1*
Start Date: Required Date Reference:	3/5/2013 : 3/19/2013	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:				
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I 130 *120* Packaging Packaging	D .	Operation Description Identify as per dwg & Sto	ock Location: WA 4	Set Up/ Run Hours 0.00	Tool ID		Accept Re Qty Qt	-	Reject Number	Insp. Stamp

140

QC21- Final Inspection - Work Order Release

0.00

*14**0***

Quality Control

Memo

0.00

13/5/14 DH MP 13-4-25

Page 2

NCR: Y	es / No				WORK ORDER NON-O	CONFOR	MANCE / UP	DATE			**
	•						· .		QA Closed:	Date	2:
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
					Rework] [Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo				Scrap	→ 1	Machining	Small Fab	-	d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update	Large Fab Compos			j	Supplier	<u> </u>
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	1	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data					•						
quip/Tooling										`	$ \hat{I} $.
Operator					· ·						
Material		1		ž.				,			:
Setup	_	į		**	hz.			¥ ∌			
Other	_			T.	grafic ^a or				;	,	
rocess	_	1.			<i>*</i>						
Supplier	_	1							1		1
Training						*					1 :
inapproved		ــــــــــــــــــــــــــــــــــــــ				L AULT CATI	GORY		<u></u>	1	· · · · · · · · · · · · · · · · · · ·
Landir	ng Gear				General	AOLI CAII					
[Bending				Bend	Grain		* *	Ovalized	. П	Pressure/Forced
Ì		lot Conce	ntric to	o/s 📙	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks			, for	Broken/Damaged	Inspec	tion Incomplete		Part Incorre	l i.	Weld
ļ	Crushed	/Crimped		ļ	Burrs	-	tions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
ľ	Cuffs	•			Contamination	Maint	enance		Part Moved		
	Heat Treat				Countersink	Mislab	eled		Positioned \	Vrong	
Ī	Inspection Strip in Tube				Cut Too Short	Misrea	d		Power Loss/	'Surge	Other
Ī	Ripples i	n Bend			Drill Holes	Offset					-
Ī	Torque V	Waves in I	Extrusio	n [Drawing	Out of	Calibration				
[Turning !	Sequence	!		Finish _	Out of	Sequence			1	
	Wave/Tv	wist in Tul	be		Folio	Outsid	e Dimensions			•	

DQA: ____ Date: ___

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Picklist Print

Tuesday, March 05, 2013 1:48:00 PM

Work Order ID: 98073

98073

Parent Item:

D3166-1

D3166-1

Parent Item Name: Basket Hoop

Start Date: 3/5/2013

Required Date: 3/19/2013

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A02.08.23New issueKJ

IPP: B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ

Verified by: EC

IPP Rev:C 09-01-23 as per DEO D3166-A2 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Rou Seq		nit of Jeasure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No		, , , , , , , , , , , , , , , , , , , ,	100	f		1,350.211	5 ,	63.15789			
M304TSC 304 SQ Tube .75x.75x.065V		065		• .	*					**	510	13-	04-99	
				<u>Location</u>			Loc Oty		Loc Code	,				
				MAT017			973.158			·				
					124069		973.158							
				WA006		3	77.053297				<u>y</u>			
4**					123303	3	77.053297		m125	_ 800	126, 71	56		

NCR:	Yes	/	No

DQA:___

Date:

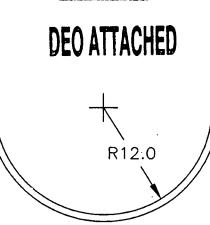
NCR: Y	es / No				WORK ORDER NON-	CONFC)RN	MANCE / UPDA		۵۸ (امتمط	Date		
										QA Closed:	Date	: ,	_
Work Orde	r·				DISPOSITION				AGAINST DE	PARTMENT/	PROCESS		
WOIK Orde	'· 				Rework	7 l		Skid-tube	Crosstube		Water Jet	Engineering	
Part N	0.				Scrap	1 I		Machining	Small Fab	Prod	d. Eng. Coor.	Quality	
					Use-as-is	† Th		noforming	Finishing		e/Packaging	Other	
NCR N	0				Work Order Update]		Large Fab (Composite		Supplier		
<u></u>		1	ı	D	tier of well-anderwoodste	Initia		Action	^	Sign &			
Root	Data				ption of work order update or Non-conformance	Chief E	1	Descript		Date	Verification	QC Inspector	
Cause	Date	Step	Qty		or Non-comormance	Ciller	-IIB	Descript	CIOII	Date	vermeation	QC IIISPECTOI	_
Ooc/Data quip/Tooling													
Operator	-	}							-				
Material	·												
ietup	-	į.											
Other											ii		
rocess													
Supplier		ŀ											
raining												,	
Jnapproved													
					F	AULT CA	ATE	GORY			•		
Landin	g Gear				General					•	-		
. ,	Bending				Bend	Gra	in			Ovalized	<u> </u>	Pressure/Forced	
	Centre No	ot Concei	ntric to (o/s	BOM/Route	Har	dwa	re		Over/Under	<u> </u>	Temperature/Cure	
	Cracks				Broken/Damaged	\vdash		on Incomplete		Part Incorred	<u> </u>	Weld	
	Crushed/	Crimped.			Burrs	——		ions Incomplete/Unc	clear	Part Lost/Mi	ssing	Wrong Stock Pulled	ţ
1	Cuffs			<u> </u>	Contamination	\vdash		nance		Part Moved			
1	Heat Trea	ət		<u> </u>	Countersink	Mis	labe	led	<u> </u>	Positioned V		_	
1	Inspectio	•	Tube	<u> </u>	Cut Too Short	\vdash	reac	d	<u>L</u>	Power Loss/	Surge	Other	
Ĺ	Ripples in				Drill Holes	Offs							
	Torque W			۱	Drawing	-		Calibration		·			
1	Turning S			_	Finish	\vdash		Sequence					
į.	Wave/Tw	ist in Tub	oe -		Folio	Out	side	Dimensions					

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DESIGN	DRAWN BY	DART AEROSP HAWKESBURY, ONTARE	
CHECKED	APPROVED	DRAWING NO.	REV. A
7/4	<u> </u>		SHEET 1 OF 1
DATÉ		TITLE	SCALE
 02.07.10		BASKET HOOP	NTS
A	02.07.10	NEW ISSUE	
AI de Gi	04.04.08	38+/-1 WAS 36.0	



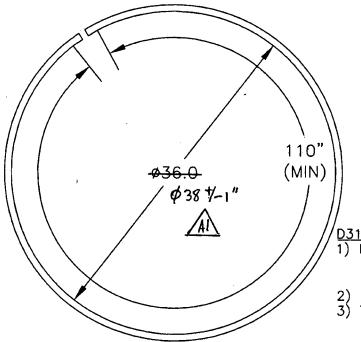
10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

1) MATERIAL: AISI 304/316 SS SQUARE TUBING. $0.75" \times 0.75" \times 0.063$ WALL, 60.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



98073 HB-83-5-

D3166-3 BASKET HOOP

MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 120.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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						•						DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFOR!\	ANCE / UP	DATE		•		·	₩-
										····	'	QA Closed:	D	ate:	
Work Orde	or.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		•
Part N ≈ NCR N	No.					Rework Scrap Use-as-is Work Order Update	Crosstube Small Fab Finishing Composite					Engineering Quality Other			
Root						ption of work order update		Initial	Act			Sign &			·
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	\downarrow	Date	Verificati	on ^l	QC Inspector
Doc/Data Equip/Tooling		N. T. B. Williams													
Operator Material															
Setup							1								·
Other															
Process	H										ļ				
Supplier													•		
Training			ĺ		 			-							
Unapproved							<u> </u>								
						F	AUI	T CATE	GORY						
Landi	ng (ear				General	_	7		_		ı			7
		Bending				Bend		Grain		<u> </u>	-	Ovalized		\vdash	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	_	Hardwa		<u> </u>		Over/Under		 	Temperature/Cure
		Cracks				Broken/Damaged		-1 `	on Incomplete	L	\dashv	Part Incorre			Weld
	L	Crushed/	Crimped.			Burrs		-	ions Incomplete/l	Jnclear	\dashv	Part Lost/M	issing	L	Wrong Stock Pulled
		Cuffs				Contamination		Mainte		L		Part Moved			
		Heat Trea	rt			Countersink	L	Mislabe	led			Positioned V	_	_	7
	Inspection Strip in Tube					Cut Too Short	1	Misread	l		-	Power Loss/	Surge		Other

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Drill Holes

Drawing

Finish

Folio

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

DRAWING N	Ο.	TITLE			1	REVA1	DART	AER	OS	PACE LTD	D.E.C	O. NO.	s	HEET NO.	SCALE
D3166		BASKET H	OOP			'	ENG	INEEF	RIN	IG ORDER	D31	66-A-2		1 OF 1	NTS
DRAWN	AJS		CHECK	ΞD	5		MFG. AF	PR. Z	V		APPROV	ED M	DE APF	PR_#	
DATE	08.12.	11	DATE	୧୫.	2.15		DATE	OX	//2	2/15	DATE	08/12/16	DATE	08-12-16	
								7							

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING, 60.00" LONG REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 60.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING, 120.00" LONG REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 120.00" LONG (REF DART SPEC. M304TS0.750W.063)



REASON: SEE PAR 08-005

		DQA:	Date:	*
ICD: Var / Na	MODE ODDER NON CONFORMANCE / LIDDATE			**

NCR: Yes / No	WORK ORDER NON-CONFOR
---------------	-----------------------

		•							QA Closea:	Date:	region .
Work Orde	r:				DISPOSITION AGAINST DEPART			PARTMENT	ARTMENT/PROCESS		
Part No.				· .	Rework Scrap	I	Skid-tube Crosstube Machining Small Fab		Water Jet Prod. Eng. Coor.		Engineering Quality
NCR No.					Use-as-is Work Order Update	Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite		~			Other
Root	PE TO SERVE	-		Descr	iption of work order update	Initial	Act	tion	Sign &		
Cause	Date.	Step	Qty.		or Non-conformance	Chief Eng	Desc	ription	Date _	Verification	QC Inspector
Doc/Data Equip/Tooling Operator											
Material	-					1					
Setup		į								į	
Other			ļ		.*						3
Process 🦂											Anne Age
Supplier -					•						
Training										·	
Unapproved					· · · · · · · · · · · · · · · · · · ·					<u></u>	
						AULT CATE	GORY				
Landir	ng Gear		,	į	General				1	·	- Calair A
	Bending	*	3	* 2 *	Bend	Grain			Ovalized	-	Pressure/Forced
	Centre-Not Concentric to O/S		BOM/Route	Hardw	Hardware		Over/Under tolerance		Temperature/Cure		
	Cracks				Broken/Damaged	—	tion Incomplete		Part Incorre	<u> </u>	Weld
- /	Crushed/	Crimped		_	Burrs Instructions Incomplete/Unclear		Unclear	Part Lost/M		Wrong Stock Pulled	
,	Cuffs				Contamination	⊢	enance		Part Moved		4
,	< ☐ Heat Trea				Countersink	Mislab		<u> </u>	Positioned \	_	7
	Inspection		Tube	_	Cut Too Short Misread		L	Power Loss/Surge		Other	
601	∸ 1 ``	tipples in Bend			Drill Holes	⊢	Offset				
	Torque Waves in Extrusion		Drawing	├ ──	Out of Calibration						
.	Turning S	-			Finish	\vdash	Sequence				
	Wave/Twist in Tube 🍮			Ì	Folio 💞	Outsid	e Dimensions				

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